Date

Tuesday, 29/04/2008 9:22:49 AM

User: Julie Lecocq

Process Sheet

Customer Job Number

Prsht Rev.

First Issue

: CU-DAR001 Dart Helicopters Services

: 38867

Estimate Number

: 12734

P.O. Number

This Issue

: 29/04/2008

S.O. No. :

: NC

: // : 38162

: SMALL /MED FAB Type

Part Number

Drawing Name

: D353525

Drawing Number

: D3535 REV B

: WEARSHOE

Project Number

; N/A : B

Drawing Revision Material

Due Date

: 08/05/2008

Qty:

20 Um:

Each

Checked & Approved By

Previous Run

Written By

Comment

New Issue 07-02-15 JLM : Est Rev:A

As per Rev B 107-08-31 JLM Est Rev:B

Verified By:EC

Additional Product

Job Number:



Seq. #: 1.0

Machine Or Operation:

Description:

M304S20GA

0.5355 sf(s)/Unit

304/316 .040 Sheet

Total: 10.7100 sf(s)

304/316 .040 Sheet (M304S20GA)

Batch:

2.0 WATER JET

Comment: Qty.:



Comment: FLOW WATER JET

1-Cut as per Dwg D3535 Dwg Rev:_______

Prog Rev:_

8-5-1

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK



5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326

2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

SB 105/15

W/O:			V	VORK ORDER CH	ANGES					
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Part No	:	PAR #:	_ Fault Ca	tegory:	NC	R: Yes	No DQA	.:	_ Date: _	
						QA: N	/C Closed	:	_ Date: _	
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		Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
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Date: Tuesday, 29/04/2008 9:22:49 AM User: Julie Lecocq **Process Sheet** Drawing Name: WEARSHOE Customer: CU-DAR001 Dart Helicopters Services Job Number: 38867 Part Number: D353525 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP 00 7.0 POWDER COATING Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE** FINISH TIME: 8.0 QC3 INSPECT POWDER COAT/CHEMICAL රල් Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 **PACKAGING** PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 08-05-Location: F P 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

W /O:		WORK ORDER CH	IANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

		WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B			Approval	Approval			
Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section C	STEP Description of NC Section A Initial Action Description Sign & Section C Chief Eng			

DART AEROSPACE LTD	Work Order: (38867
Description; Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST							
	X	First Article		Prototype	e			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
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5.450	+/-0.010	5,453	×					
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	9-5-1		58/05/01		Da	te: N/A		
Rev Date	Change				Revised	by Approved		
A 07.11.23	New Issue				KJ/EC/D	D. XI		

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RELEASED

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07.04.17

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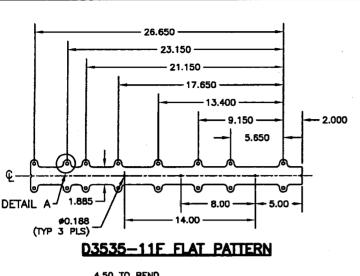
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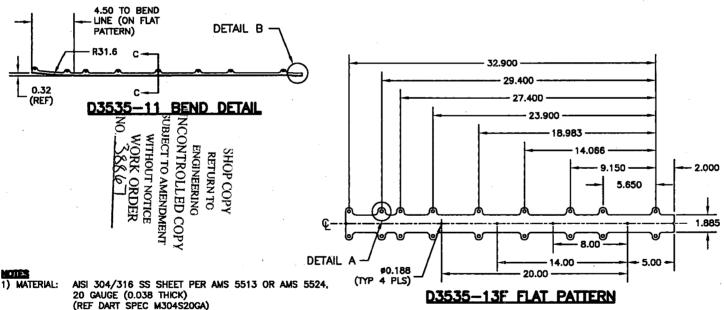
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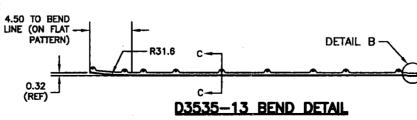
PURPOSE

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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



W/O:			WORK ORDER CHANGES								
DATE	STEP	PROCEE	URE CHANGE	Ву	y Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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QA: N/C Closed: ____ Date: ____

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W/O:		WORK ORDER CHANGES									
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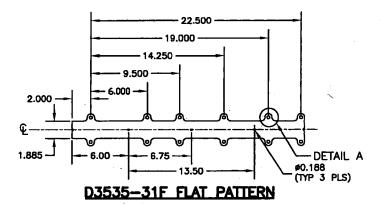
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WEARSHOE

DETAIL A







D3535-31 BEND DETAIL

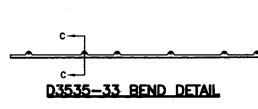
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D3535-33F FLAT	PATTERN

c —		33 BEND DETAIL	
c			
D3535	-33 BEI	ND DET	AL

- AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) 1) MATERIAL:
- (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) PART IS SYMMETRICAL ABOUT Q
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



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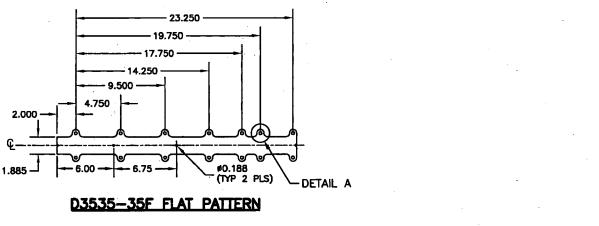
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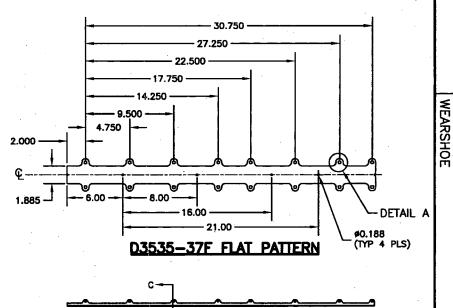
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AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)

- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

1) MATERIAL:

- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-37 BEND DETAIL

PURPOSE

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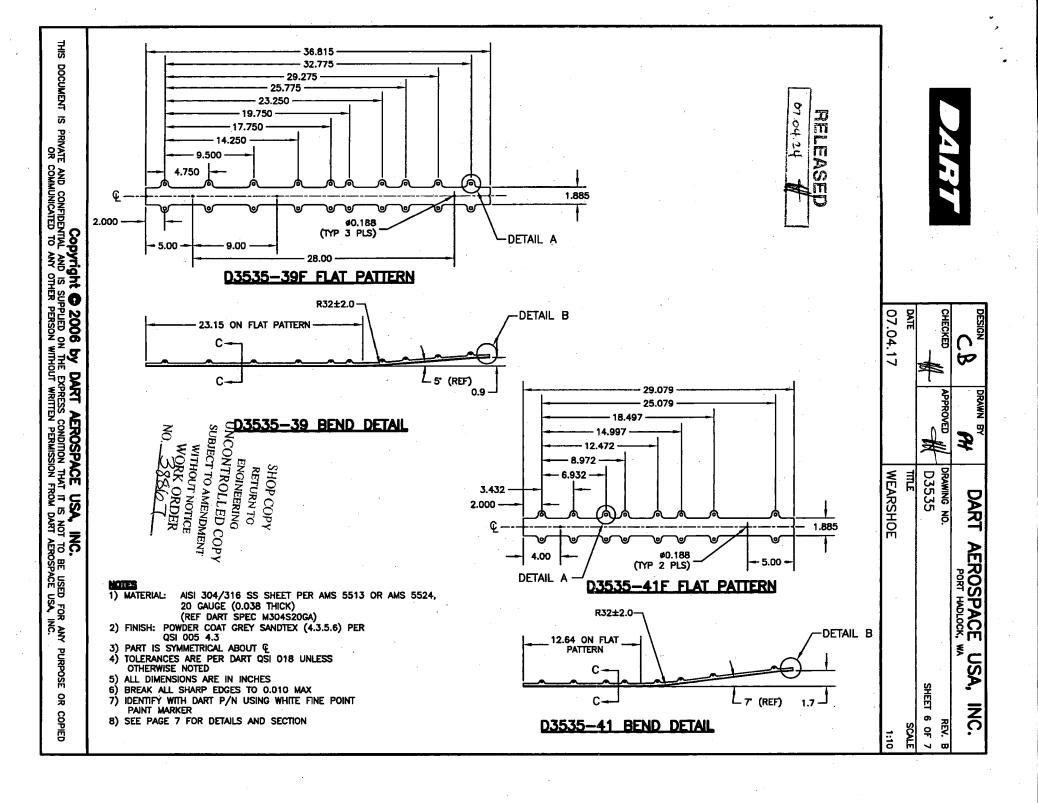
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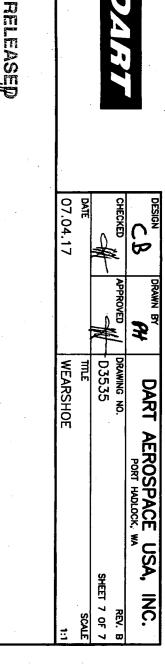
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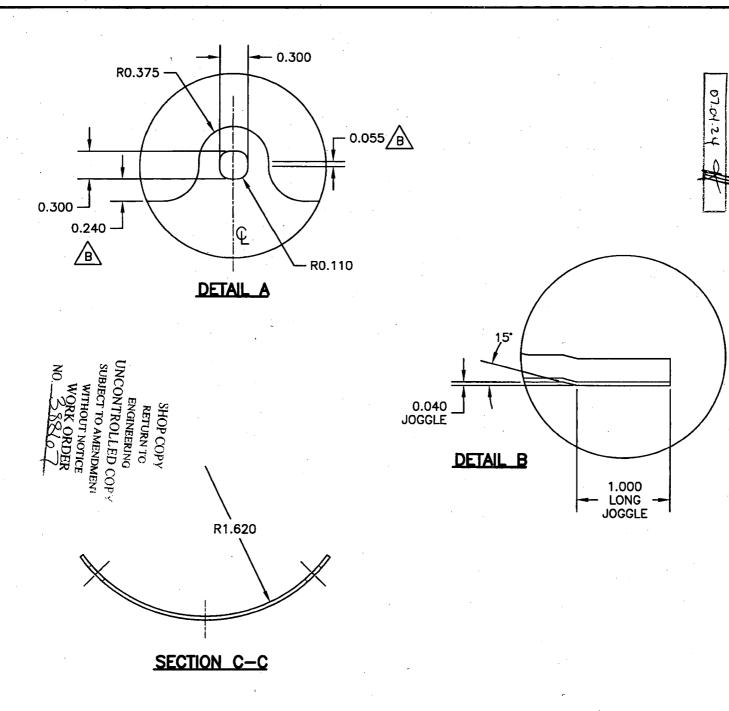
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